

Work Order ID 67988

Tuesday, April 05, 2011 10:41:00 AM

Page 1

Item ID: D4380-3
Revision ID: PRELIM
Item Name: Vent, Fwd

Accept

Setup Start

Stop

Start Date: 4/5/2011 Start Qty: 2.00
Required Date: 4/5/2011 Req'd Qty: 2.00

Cust Item ID:
Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: *MF* Date: *11-04-05* Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4380	PA6 <i>PA7</i>	<i>11/04/05</i>	<i>ADJ</i>						

100 0.00



HandThermo

Memo

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

2

BB
11/04/06

105 0.00



HandThermo

Dry Material

Memo

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

Temp: *150°F*

Time IN: *6:00 pm* *11/04/04*

Time OUT: *7:00 am* *11/04/05*

2

BB
11/04/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Thermoform

Thermoforming Machine

Memo

0.00

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA111 using tool DT9736

Dwg Rev: PA7

Folio Rev: A

2

11/04/06

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Visually inspect part for proper formation and texture

2

11/04/06

130

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

2

11/04/05

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Page 3

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Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

2

Wh

11/04/05

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

2

Wh

11/04/05

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

- inspect to PA 2

Don only

8/10/06

(72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>RA66</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
180	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

POSITIVE RECALL

EFFECTIVE 7/24/05AUTH CLRELEASED WDATE 11/05/1311/5/16 RF

CNF

11-04-06

RD2370

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:40:58 AM

Page 1

Work Order ID: 67988

Parent Item: D4380-3

Parent Item Name: Vent, Fwd



Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Rev. A New Issue. 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	6.9375			



6185 KYDEX .080"



Location

therm

Loc Qty

787.2912

Loc Code

787.2912

116576

Sh
11/04/06

6.9375 sq ft

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 67998.
Description:	Part Number: D4380-3
Inspection Dwg: D4380 Rev: PA7	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4"</u>	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>DL</u>	Date: <u>11/04/05</u>
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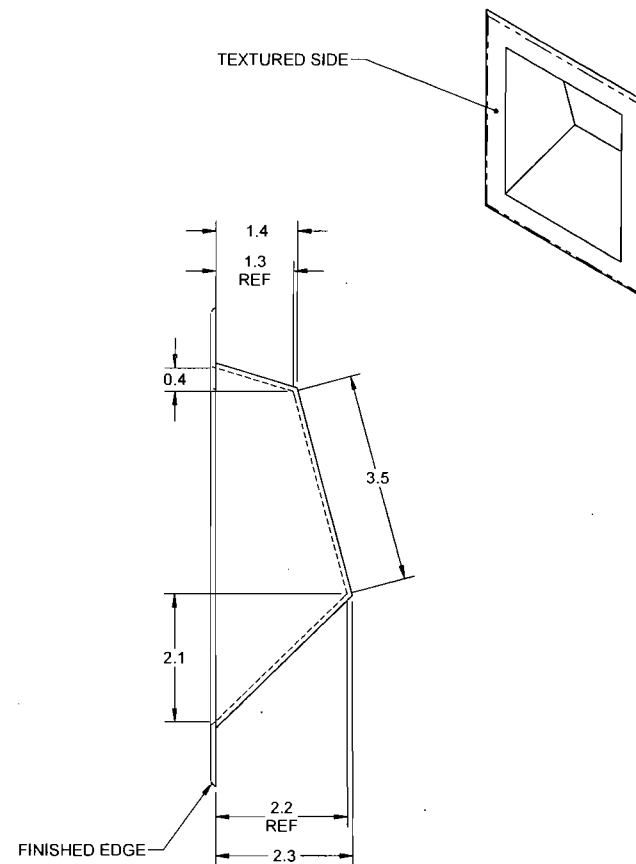
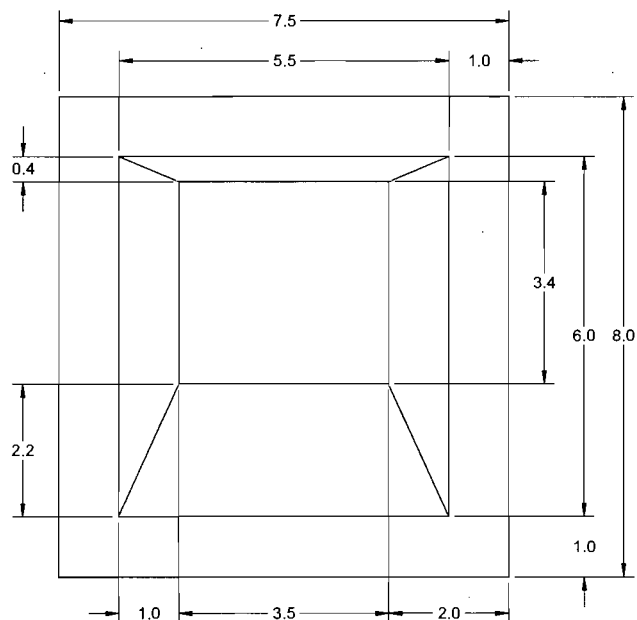
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.5"	± .100	7.5"	✓			
5.5"	± .100	5.5"	✓			
8.0"	± .100	8.0"	✓			
6.0"	± .100	6.0"	✓			
3.4"	± .100	3.4"	✓			
3.5"	± .100	3.4"	✓			
1.3"	± .100	1.25"	✓			
2.2"	± .100	2.25"	✓			
1.0"	± .100	1.0"	✓			

Measured by: <u>DL</u>	Date: <u>11/04/05</u>
Audited by: <u>S to PA7 Dwyer/ly</u>	Date: <u>11/04/06</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -3 PART PER MOULD DT9736.
TRIM PER MOULD LEAVING FINISHED EDGE.

D4380-3 VENT, FWD

PRELIMINARY ISSUE

BC 11.04.05

DESIGN	<i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>		
CHECKED		DRAWING NO. D4380	REV. PA7
MFG. APPR.			SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		CEILING POCKETS	NTS
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Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Saturday, April 02, 2011 5:44 PM
To: 'Daryl Leger'
Cc: 'Eric Charbonneau'; 'JEANLUC MENARD'; 'Linda Lacelle'; Bill Beckett; 'Harvey Siemens';
'David Shepherd'
Subject: D4380 Issues

Hi Daryl,

Please see D4380-PA6 in the Prelim folder.

Fortunately, the guys were still here and I talked to them about the manufacturing issues.

Based on their feedback, I have modified the D4380-17 cover. It should be a little easier to manufacture.

However, the -3/-5/-27/-29 need to stay as they are. Please use the "cheat the corners" technique to make the part as true to the drawing as possible. There are spare air conditioning vents here – we could fedex you one on Monday if that would help in creating the moulds.

The only thing I changed in the PA6 rev was the -17.

As for cutting out the "tops" of the round parts (-21/-23/-25 etc), it is up to you. If you would like to cut it out and trim it, that's ok, or the guys here can do that.

Thanks Daryl,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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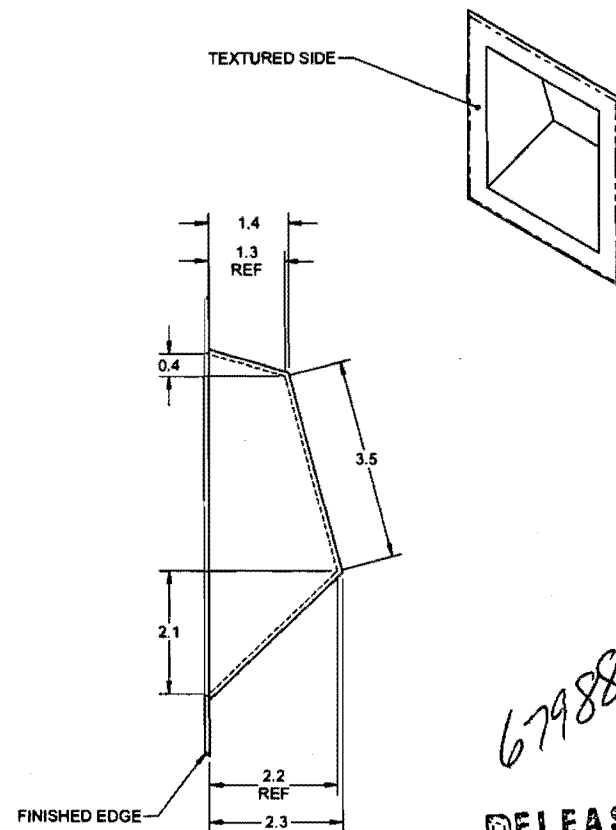
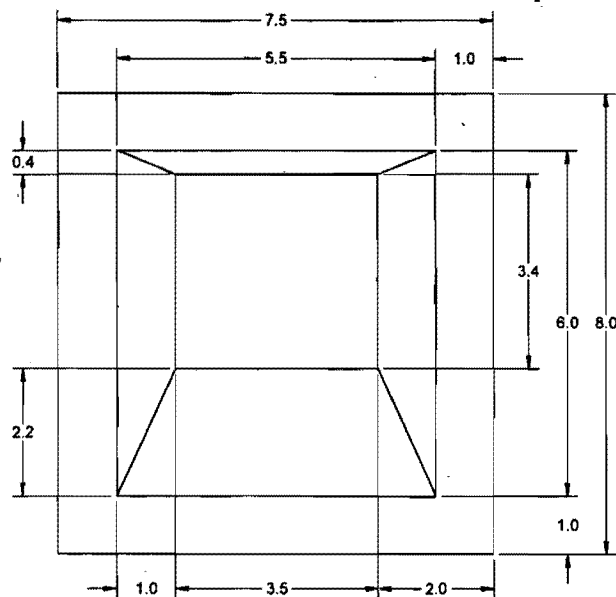
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.31 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOULD DT9736 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE
- 11) MAXIMUM INSIDE RADIUS = 0.188

D4380-3 VENT, FWD

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D4380	SHEET 2 OF 19
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CEILING POCKETS	NTS
DATE	11.04.21	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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67988
RELEASED
2011-05-10

